	er ID 87894 7, 2012 2:36:27 PM		*878				Page 1	-			
Item ID: Revision ID: Item Name:	D412-761-051 Alternate Armrest		Accept	*N900	040	100)*	Setup Star	1.71	S1*	_
Start Date: Required Date: Reference:	7/17/2012 Start Qty: 2			Cust Item I Customer:	D:			510	, *N	S2*	
Approvals:	Process Plan:F	Date:\\Q-\O\\^-\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	\frac{1}{7} Tooling: SPC (Y/N):		ate:			Run Star Sto	17	R1* R2*	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
Draw Nbr	Revision Nbr							1			
DSI 9520 IIN D412-761	A D										
*1 \\ \n \\ \text{DC} \\ \text{DC Uncurrent Control}	CHG	o copy bluefile & type labels per		12/03/3.				_mui	5126	57/3	ð
*110 *110*	Pick Kit		0.00						Isl	71305)
Packaging	· Mem	0	0.00							1	

Memo

Packaging

		DQA:	Date:	
ICD. Voc / N	WORK OPDED NON-CONFORMANCE / LIDDATE			

	,										Q	(A Closed:	Dat	e:	
Work Orde	ar.					DISPOSITION				AGAINST D	DEPA	ARTMENT/	PROCESS		
Work Orac	·'· <u> </u>					Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo					Scrap			Machining	Small Fab		Prod. Eng. Coor.			Quality
NCR N	lo		<u>-</u>			Use-as-is Work Order Update			noforming Large Fab	Finishing Composite					Other
Root	<u> </u>				Descri	ption of work order update	ln	itial	Ac	ction		Sign &			
Cause	(Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Desc	cription		Date	Verification	1	QC Inspector
Doc/Data															
Equip/Tooling															
Operator															
Material								• -							
Setup]	e e							
Other							0	ĘΩ,						ļ	
Process															
Supplier											1				
Training															
Unapproved															
						F	AULT	CATE	GORY						
Landir	ng Gea	r				General							,		
	Ве	nding				Bend	\square	Grain				Ovalized		Ш	Pressure/Forced
	Ce	ntre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	Cr	acks				Broken/Damaged		nspecti	ion Incomplete	L	F	Part Incorred	t		Weld
	Cri	ushed/C	rimped.			Burrs		nstruct	ions Incomplete,	/Unclear	F	Part Lost/Mi	ssing		Wrong Stock Pulled
	Cu	ffs				Contamination		√lainte	enance	Ĺ	F	Part Moved			
	He	at Trea	t			Countersink		Mislabe	eled		F	Positioned V	Vrong		
	Ins	pection	Strip in	Tube		Cut Too Short		Misread	d _.	. [F	Power Loss/	Surge	Ш	Other
	Rip	ples in	Bend			Drill Holes		Offset		-	· _				
Torque Waves in Extrusion Drawing			Drawing	Out of Calibration											
Turning Sequence Finish			Out of Sequence												
			Folio	Outside Dimensions											

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	er ID 87894 7, 2012 2:36:27 I			*878	394*				,,		Page 2	2
Item ID: Revision ID:	D412-761-051			Accept	*N900	<u>040</u>	100)* s	etup Star	* *N	S1*	T-11-E
		eq'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:			Stop	' *N	S2*	
Approvals:	Process Plan: _ QC:		Date:	Tooling: SPC (Y/N):	·	ate:		R	tun Star Stop		R1* R2*	
Sequence ID/ Work Center II 120 *120* QC Quality Control) De	peration escription E4- 100% Inspect kits : Memo	for completeness	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*130 *130* Packaging	Pac	ckaging Memo Identify and Location:		0.00 0.00 PPPD412-761-051/ DSI95	520					la	1330	5

140

QC21- Final Inspection - Work Order Release

0.00

140

0.00

Quality Control

Memo

N(201/30

											ĺ	DQA:	Dat	e: _	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	/ANCE / UP	DATE					
											QA Cl	osed:	Dat	e:	
Work Ord	or.					DISPOSITION				AGAINST D	EPARTN	1ENT	/PROCESS		
Work Ord	C1.					Rework	7		Skid-tube	Crosstube	7		Water Jet		Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Prod. Eng. Coor.			\dashv	Quality
						Use-as-is		Thermoforming Finishing			Rec/Store/Packaging				Other
NCR I	No.					Work Order Update]		Large Fab	Composite			Supplier[_]	
Root					Descri	ption of work order update		Initial	Ac	tion	Sign	&			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Da	te	Verification	ր	QC Inspector
Doc/Data			1			•									
Equip/Tooling			ŀ				-						1		æ .
Operator	Ш		[•					I	
Material															
Setup														ŀ	
Other															
Process															
Supplier									•	•					
Training								I.E.							
Unapproved						·		**************************************							
							FAUI	LT CATE	GORY						
Landi	ing (Gear				General		_		<u></u>	_		•		
		Bending			<u> </u>	Bend	L	Grain		L	Ovaliz				Pressure/Forced
	L	Centre N	ot Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/	Under	tolerance		Temperature/Cure
	Cracks				Broken/Damaged	L	Inspecti	on incomplete		Part Ir	corre	ct		Weld	
Crushed/Crimped. Burrs						Instruct	ions Incomplete	'Unclear	Part L	ost/M	issing	<u> </u>	Wrong Stock Pulled		
Cuffs Contamination						Mainte	nance		Part N	1oved					
		Heat Trea	at			Countersink		Mislabe	led		Positioned Wrong				
		Inspectio	n Strip in	Tube		Cut Too Short	Misread Power Loss/Surge Ot				Other				
		Ripples in	n Bend			Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Page 1

Work Order ID:

87894

Parent Item:

D412-761-051

Parent Item Name:

Alternate Armrest

Start Date: 7/17/2012

Required Date: 7/27/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:	535 DD VERF:EC	ue DD 10.05.18 v	erf:EC		IPP REV:	B 12.03.06 A	AS PER EC	CN12-			•		
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-6 Castellated Nut	,	Purchased	No			110	Each	7.0000		2	47.	- Aut	
				Location		Loc Oty	<u>L</u>	oc Code	, '				
				ST344		7							
				110	139	7			2			$\hat{}$	_
AN3-6A Bolt		Purchased	No			110	Each	233.0000	101	V 22	- HH 3)	4
				Location		Loc Qty	<u>L</u> .	oc Code			1		
				ST351		233			<u> </u>				
,				117		34			43				
				120	060	49 50			0				
				121		100				^			
AN6-26 Bolt		Purchased	No	• •		110	Each	4.0000	T	2		×	<
4				Location		Loc Qty	L	oc Code					
				ST342		÷ 4							\wedge
				. 112	489	4							- 1)
AN960JD10 Washer	NAS1149D0363J	Purchased	No			110	Each	0.0000	W .	22	m	1215	42 re
Washer	•	Purchased	No			110	Each	0.0000	1	2	M12	04/85.	
MOUNTING PLATE		Manufactured	No			110	Each	0.0000	0	2	138	189	6 Sf
D3695-041 Slider Assembly		Manufactured	No			110	Each	0.0000	3	2	687	B98	12/7/
D21097-041 Armrest Assembly		Manufactured	No			110	Each	0.0000	0	2	B87	704	2

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UF	PDATE			
											QA Closed:	Date:	
Work Orde	er.					DISPOSITION				AGAINST DE	EPARTMENT,	/PROCESS	•
Part No						Rework Scrap Use-as-is Work Order Update	rap s-is		Skid-tube Crosst Machining Small Thermoforming Finish Large Fab Compo		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		Initial	А	ction	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
	FAULT CATEGORY												
Landi		ear Bending			Г	General Bend		Grain		Γ	Ovalized		Pressure/Forced

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

BOM/Route

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish Folio

Burrs

Broken/Damaged

DQA:

Over/Under tolerance

Part Incorrect
Part Lost/Missing

Part Moved

Positioned Wrong

Power Loss/Surge

Date:

Temperature/Cure

Wrong Stock Pulled

Weld

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

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Picklist Print
Tuesday, July 17, 2012 2:36:26 PM

Work Order ID:	87894	**								•	
. Parent Item:	D412-761-051	:						Start	Date: 7/17/2012	Require	ed Date: 7/27/2012
Parent Item Name:	Alternate Armrest							Star	t Qty: 2.00		ed Qty: 2.00
MS21071L3 ANCHOR NUT	en de la companya de	Purchased	No			110	Each	82.0000	<u>3</u>	6	S) 4
En .		1- ees		Location		Loc Qty		Loc Code			
			••	ST302		82 32			6	_	•
MS2107513 Nutplate		Purchased	No	114348		110	Each	87.0000	M la	- 16 24 5 3	
Nutplate				Location	1 2	Loc Qty		Loc Code		2130	3
				ST303 — 120910		1				_	
		•		ST321		86					
				121825 122141		36 50			<i>F</i> *	<u> </u>	
MS24665-302 Cotter Pin		Purchased	No			110	Each	156.0000	2	2	
1 <u>.</u>				Location		Loc Qty		Loc Code			-
				ST309 120521		156 156			2	_	
NAS1515H6L WASHER		Purchased	No		•	110	Each	38.0000	273/7/	36	2
				Location		Loc Qty		Loc Code			
	•			ST277 18918		38 38			. — 🗸	_	
•		~		10319		38					

DQA:	Date	· ·

WORK ORDER NON-CONFORMANCE / UPDATE

Initial

Chief Eng

FAULT CATEGORY

Out of Sequence

Outside Dimensions

DISPOSITION

Work Order Update

Description of work order update

or Non-conformance

General

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Broken/Damaged

Rework

Use-as-is

Scrap

NCR: Yes / No

Root

Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved

Landing Gear

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Work Order:

NCR No.

Date

Part No.

Step

Centre Not Concentric to O/S

Qty

TOMINATELY OF DATE	QA Closed:	Date:										
AGAINST DEPARTMENT/PROCESS												
Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other									
nitial Action ief Eng Description	Sign & Date	Verification	QC Inspector									
	•											
T CATEGORY												
Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other									
Out of Calibration												

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

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PARTS LIST

	QTY -051	PART NUMBER	DESCRIPTION
	X	D412-761-051	ARMREST KIT, LH
<u> </u>	_1_	-D3694-0417	MOUNTING PLATE ASSEMBLY
¢		D3694-1	* KEYWAY
	1	D3694-3	* PROTECTIVE PLATE
_	1	D3694-5	* MOUNTING PLATE
Г	1	AN526C1032R8	* SCREW
	5	AN960JD10	* WASHER
	4	MS21042L3	* NUT
	2	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
Г	1	MS24693-C271	* SCREW (OR MS24693-S271)
	4	MS24693-C273	* SCREW (OR MS24693-S273)
十	1	D3695-041/	SLIDER ASSEMBLY
-	1	D3695-1	* SLIDER
\vdash	1	D3695-3	* STOPPER
	1	D3801-1	* HAND RETRACTABLE SPRING PLUNGER
\vdash	1	MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
Г	4	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
	4	MS24693-C276	* SCREW (OR MS24693-S276)
1	1	D4097-041 /	ARMREST ASSEMBLY
"	1	D3696-041	* ARM ASSEMBLY
Г	1	D3696-1	** ARM
	1	D3801-3	** HAND RETRACTABLE SPRING PLUNGER
Г	1	D4098-041	* CUSHION ASSEMBLY
Г	1	D4099-1	* BRACKET
	3	MS21042L3	* NUT
	5	MS24693-C273	* SCREW
	3	MS24693-C277	* SCREW
	3	NAS1149D0332J	* WASHER
-	, 11 =	-AN3-6A	BOLT
1	_1	AN6-26	BOLT
E	.1	AN310-6	CASTELLATED NUT
4	11	AN960JD10	WASHER
Æ	1	AN960JD616L /	WASHER
7	2	NAS1515H6L	*WASHER
	1	_MS24665-302	-COTTER PIN
Œ	3 -	MS21071L3 7	ANCHORNUT
7	8	MS21075L3 /	NUTPLATE

MS21075L3 / NUTPLATE

* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

10.05.10 DATE: CERT. NO.: SH09-4 ISSUE NO .: _

DESIGN	-61	DART AEROSPACE	LTD
DRAWN	-8	HAWKESBURY, ONTARIO, CAN	IADA
CHECKED	P	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9520	SHEET 2 OF 3
APPROVED	149	TITLE	SCALE
DE APPR.	-#	ALTERNATE ARMREST INSTALL	NTS
DATE 10.0	5.10	COPYRIGHT © 2010 BY DART AEROSPAC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPENDED TO TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY	ESS CONDITION THAT IT IS

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